

slip Oct. 3

Dart Aerospace Ltd.

Date: Monday, 10/1/2007 1:37:22 PM
User: Kim JohnstonSPLIT WO
SBS 07/10/07

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM	
Job Number	: 34919				
Estimate Number	: 12172				
P.O. Number	: N/A		Part Number	: D2066	
This Issue	: 10/1/2007	S.O. No. : N/A	Drawing Number	: D2066 REV B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: N/A		Material	: N/A	
Written By			Due Date	: 10/8/2007	
Checked & Approved By	:  07.10.01		Qty:	3 Um: Each	
Comment	: Est. D 02.03.18 Added pick list NG				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M304TR0500W035	304 RD Tube .500 x .035W			
Comment: Qty.: 2.5043 f(s)/Unit Total : 7.5128 f(s) 304 RD Tube .500 x .035W Punch 1/2" OD x .035" Wall 304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2066 Use punch Jig DT8012 Batch: H105575					
MF 07-11-14					
2.0	D2052	Bracket			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Bracket Pick: Qty Part number Description Batch					
2 D2052 Bracket B17214 SBS					
3.0	D2055	Clamp			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Clamp 1.0 Pick: Qty Part number Description Batch					
1 D2055 Clamp B28823 SBS					
4.0	D2056	Bell Crank Assembly			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Bell Crank Assembly Pick: Qty Part number Description Batch					
1 D2056 Bellcrank B17049 SBS 07-11-14					

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/03	6	Split w/o balance of 3 pieces	SB	07/10/03	4	✓		07/11/04	
07/10/03	6	Keep 1 for Template hole off tolerance	SB	07/10/03	1	✓		07/11/04	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 10/1/2007 1:37:22 PM
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Job Number: 34919

Part Number: D2066

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2054 Bushing - Delrin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing - Delrin

Pick:

Qty	Part number	Description	Batch
2	D2054	Bushing	B16711

SB 07/11/14 ③

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Slide on parts per Dwg and W/O for D2676-043

Punch other end to length (28.62") as per Dwg D2066

Bend per Dwg D2066

Drill 3/16" Dia holes per Dwg D2066

mf 07-11-14 ③

Deburr

mf 07-10-03

7.0 QC5 INSPECT WORK TO CURRENT STEP



INSPECT WORK TO CURRENT STEP

207-11-15 ③



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING POWDER COATING



POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

N/A R

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Record D2066 Batch number on W/o for D2676-043

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 04/11/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARM

Job Number: 34919

Part Number: D2066

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57239 K8

W

07/11/15

12.0 QC21

FINAL INSPECTION/W/O RELEASE



③

Comment: FINAL INSPECTION/W/O RELEASE

DA/11/15

Job Completion



W 07/11/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

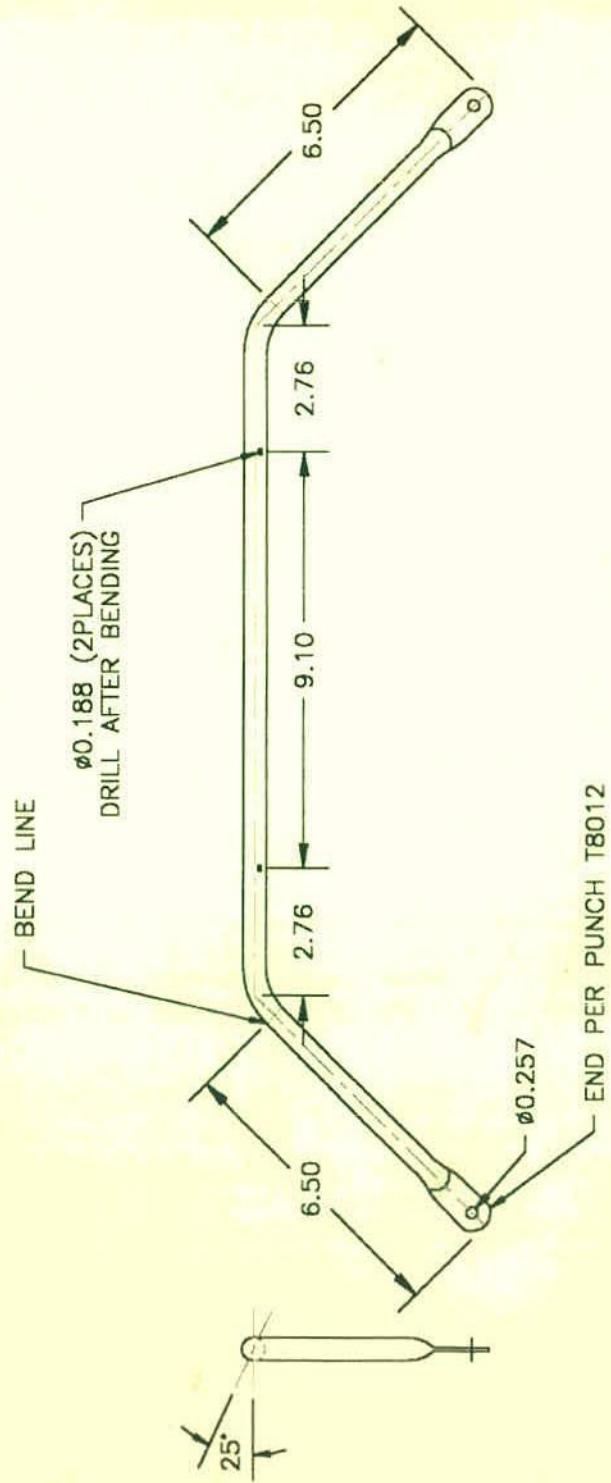
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>B</i>	APPROVED <i>J</i>	DRAWING NO. D2066	REV. B SHEET 1 OF 1
DATE 92.03.12		TITLE ARM	SCALE 1:4
B	96.02.06	RE-DESIGNED	



D2066 CUT LENGTH 28.62
NOTE:
ADD D2052, D2055, D2056
D2054 TO ARM BEFORE
ENDS ARE PUNCHED AND
ARM IS BENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34919

REFERENCE ONLY

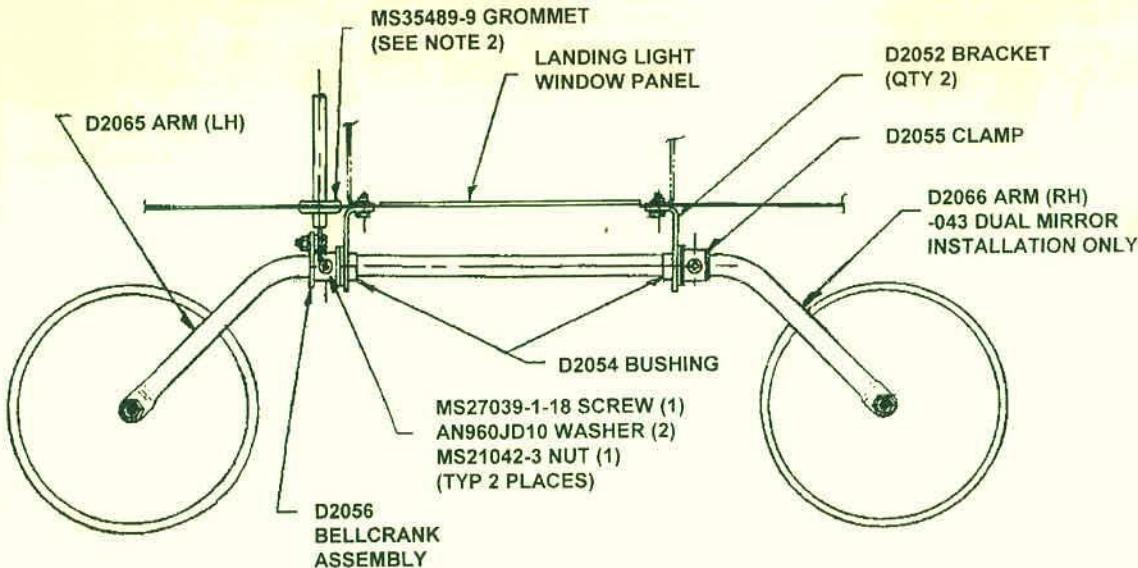


Figure 25.2 – View A: Looking Aft.
(D206-558-043 Mirror Shown)

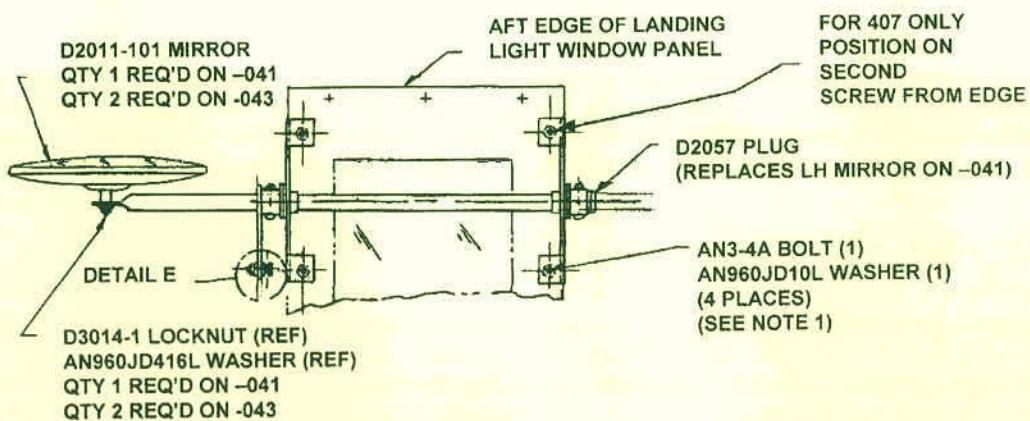


Figure 25.3 – View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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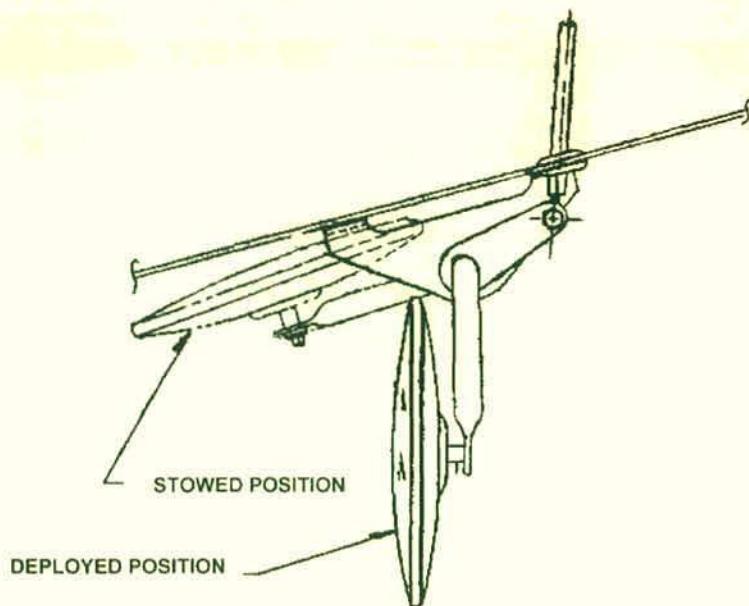


Figure 25.4 – Detail D: Looking from Side on Mirror Installation
(D206-558-041/-043 Mirror Shown)

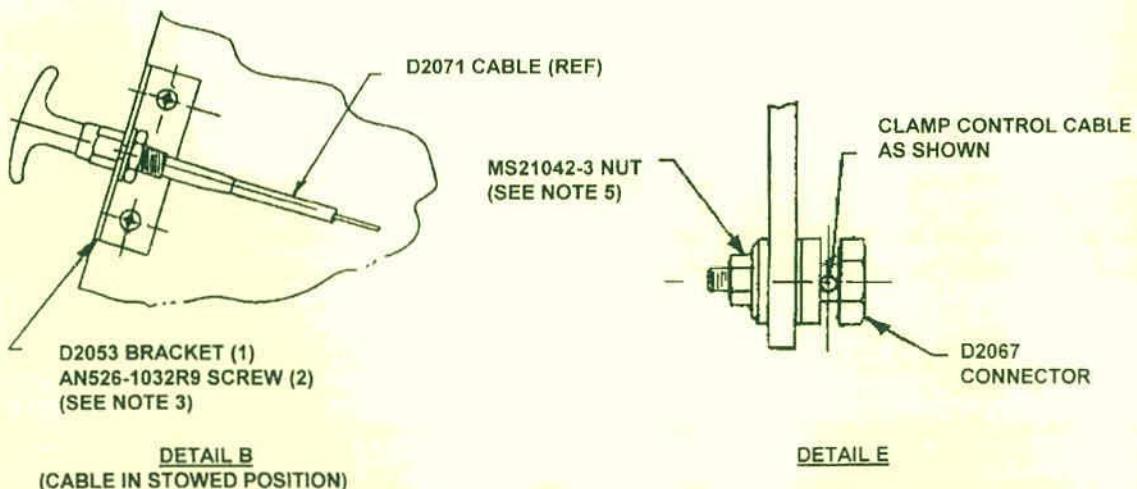


Figure 25.5 – Details B and E on Mirror Installation
(D206-558-041/-043 Mirror Shown)

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